

Work Order ID 86125

Wednesday, June 20, 2012 3:32:45 PM

86125

Fer mandos

Page 1

Item ID: D4420-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Top Leg Support Assembly
 Start Date: 6/20/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/25/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *MF* Date: *12-06-20* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4420	B								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	Gloss Grey (4.3.5.15) per QSI 005.4.3	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>11:50</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>12:20</i>								
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/06/20

1 x 12626

1 x 11/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86125

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86125

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Item ID: D4420-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Top Leg Support Assembly

Stop ***NS2***

Start Date: 6/20/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/25/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

140

Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D4420

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location

0.00

160

Packaging

Memo

0.00

Packaging

12-6-27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 86125***86125***

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Item ID: D4420-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Top Leg Support Assembly

Stop

NS2

Start Date: 6/20/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/25/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MCJ 12/06/27
MCJ 12/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, June 20, 2012 3:32:45 PM

Page 1

Work Order ID: 86125

Parent Item: D4420-043

Parent Item Name: Top Leg Support Assembly

Start Date: 6/20/2012

Required Date: 6/25/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM
rev.b DD verf:EC

IPP revB 12.03.05 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-3 Channel		Manufactured	No			110	Each	6.0000	1	1		6/20/12	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	6						
						80627	6						
MS20426AD3.4 RIVET		Purchased	No			140	Each	2,750.0000	2	2		6/20/12	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST316	2750						
						104374	236						
						110398	2514						
MS21059L4 Nutplate		Purchased	No			140	Each	59.0000	1	1		6/20/12	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST301	8						
						117887	3						
						119623	5						
						ST302	51						
						120930	1						
						121060	50						

3/01/12
2.06.00

6/20/12
6/20/12
M1210H
20
6/20/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

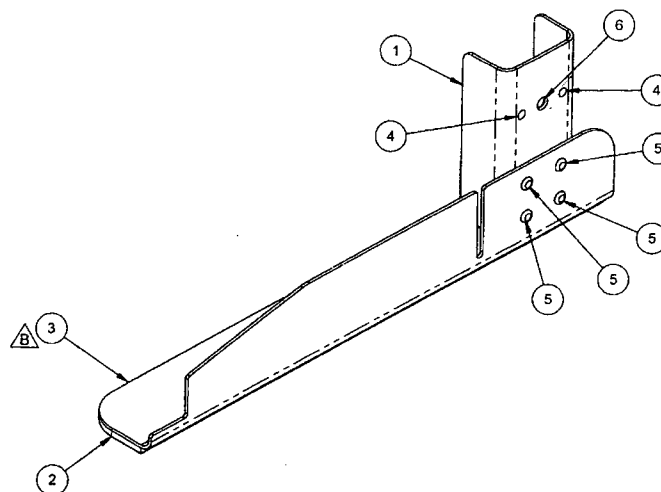
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4420-041	TOP SUPPORT ASSY
1	1	D4006-3	CHANNEL
2	1	D4006-5	FOAM
3	1	D4420-1	ANGLE
4	2	MS20426AD3-13	RIVET
5	4	MS20470AD4-5	RIVET
6	1	MS21059L4	ANCHOR NUT



D4420-041 TOP SUPPORT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-041" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.38 lbs

B	ADD RELIEFS FOR COMPATIBILITY WITH EUROCOPTER SQUIRREL CHEEK, FINISH WAS "GREY SANDEK" (4.3.5.6)	MB	12.02.21
A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.02.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4420	REV. B SHEET 1 OF 4
TITLE TOP SUPPORT ASSY	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

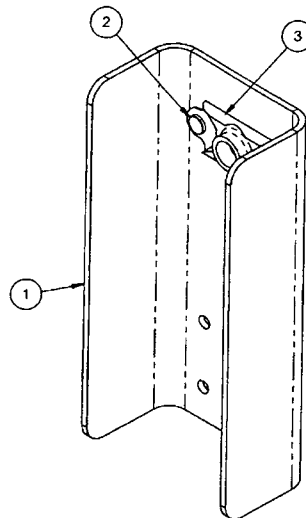
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4420-043	TOP LEG SUPPORT ASSY
1	1	D4008-3	CHANNEL
2	2	MS20426AD3-4	RIVET
3	1	MS21059L4	ANCHOR NUT



D4420-043 TOP LEG SUPPORT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 BEFORE INSTALLATION OF MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-043" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOP SUPPORT ASSY	NTS
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#86125

RELEASED
2012-03-08

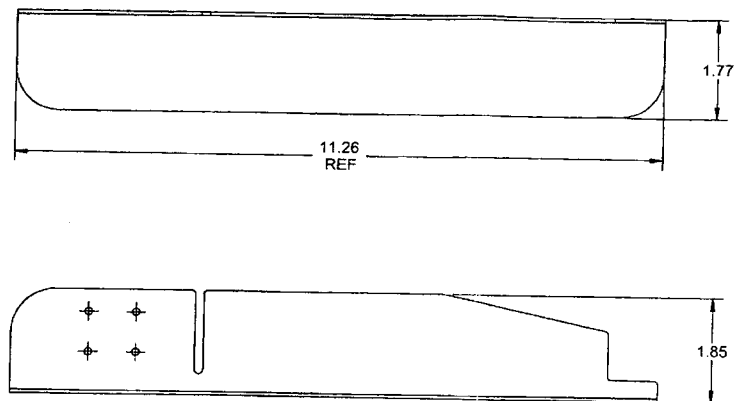
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4420-1 ANGLE

NOTES:

- 1) MATERIAL: MADE FROM D4420-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 3 OF 4
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RELEASED
2012-03-02

#86105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

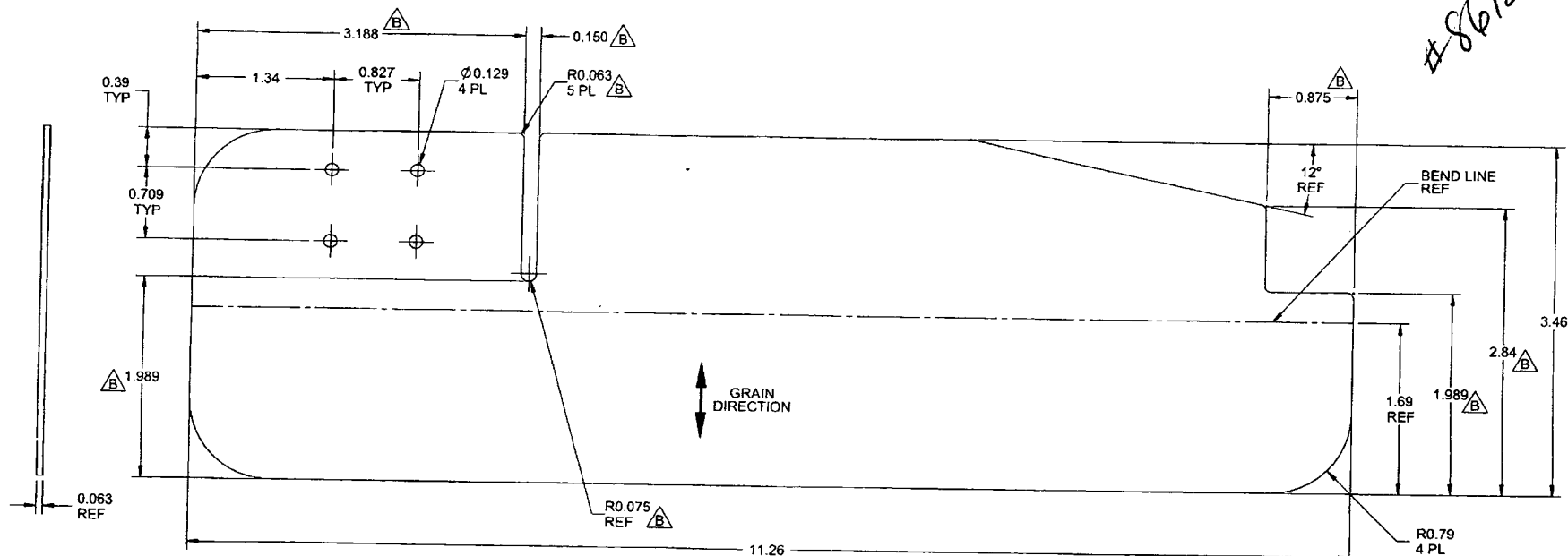
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NOTE: Date & initial all entries

#86105



D4420-1F FLAT PATTERN

RELEASED
2012-03-03
JH

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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